

Date: Thursday, 2/14/2008 2:21:00 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HI-STEP LEG ASSEMBLY		
Job Number	37452			Part Number	D2582		
Estimate Number	10355			Drawing Number	D2582 REV B		
P.O. Number				Project Number	N/A		
This Issue	2/14/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	2/25/2008	Qty:	12
Previous Run	36710			Um:	Each		
Written By	<u>MF</u> 080214						
Checked & Approved By							
Comment	Est Rev:F Removed Manufacturing 05-11-07 JLM Est Rev:G Added part # to Sub 06-08-10 JLM Est Rev H New pick list 08.01.11 EC verified by: DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	37452A	STEP LEG	
		Comment: Sub-Component STEP LEG D2278 B <u>37452A</u>	<u>mf</u>
2.0	37452B	STEP SPACER	
		Comment: Sub-Component STEP SPACER D2322 B <u>37452B</u>	<u>mf</u>
3.0	37452C	STEP SPACER	
		Comment: Sub-Component STEP SPACER D2279 B <u>32585</u>	<u>mf</u>
4.0	37452D	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3720-1 B <u>37452D</u>	<u>mf</u>
5.0	37452E	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3720-2 B <u>37452E</u>	<u>mf</u> 08-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37452

Part Number: D2582

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet M106654.

mf

7.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet M104156.

mf

08-03-06

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

mf 08-03-06

(12)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 08/03/06 (12)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA27

SL 08-03-06

12

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

mf 08/03/06

(12)

Job Completion



mf 2008/3/06

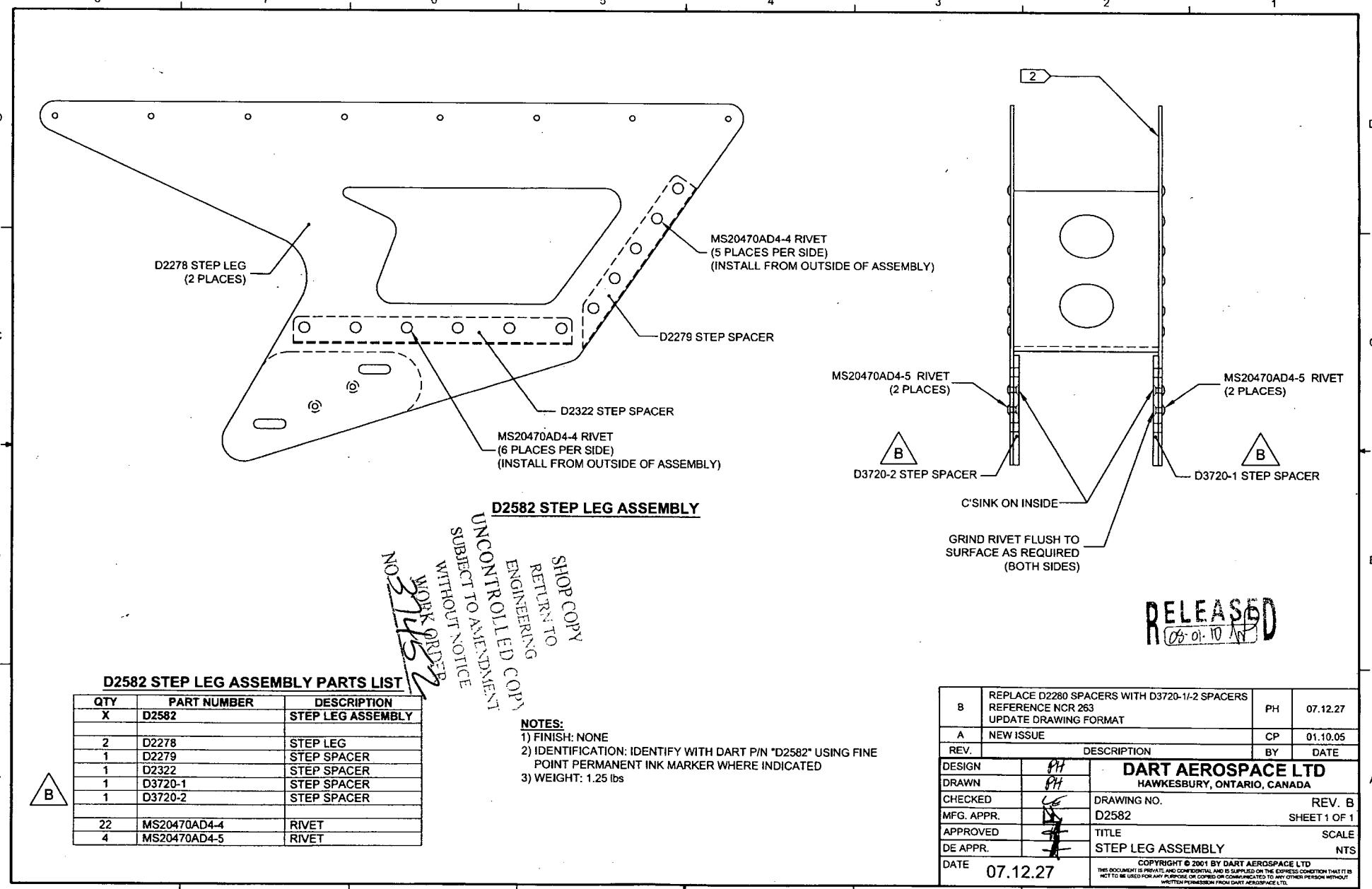
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SUB-ASSEMBLY PART LIST		
QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D3222	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

Date: Thursday, 2/14/2008 2:21:01 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP LEG		
Job Number	37452A						
Estimate Number	10353						
P.O. Number	:			Part Number	D2278		
This Issue	2/14/2008	S.O. No.	:	Drawing Number	D2278 REV F		
Prsht Rev.	NC			Project Number	N/A		
First Issue	/ /	Type	SMALL /MED FAB	Drawing Revision	F		
Previous Run	36710A			Material	:		
Written By	:			Due Date	2/25/2008	Qty:	24
Checked & Approved By	:			Um:	Each		
Comment	Est Rev:A New Issue 05-11-07 JLM						
	Est Rev:B Now 6061-T6 06-06-23 JLM						
	Est Rev C New flat pattern 08.01.11 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
32			
Comment: Qty.: 1.0306 sf(s)/Unit Total : 24.7338 sf(s) Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick (M6061T62S.080) Identify as D2278 Batch: <u>i07076</u> <u>HB 8-3-3</u>			
2.0	WATER JET	FLOW WATER JET	
 Comment: FLOW WATER JET 1-Cut as per Dwg D2278 Dwg Rev: <u>F</u> <u>HB 8-3-3</u> Prog Rev: <u>F</u> (31)			
2-Deburr if necessary <u>HB 8-3-3</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<u>HB 8-3-3</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
 Comment: SECOND CHECK <u>coats</u> <u>HB 8-3-3</u> <u>t.31</u>			

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 15 Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 37452A

Part Number: D2278

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

08-03-04

(X31)

6.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

08-03-06

(31)

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

08-03-06

(31)

8.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done 03/06

Job Completion



2008/3/06

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37452A
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

PTJ
21.02.14

Measured by:	<u>BB</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-3-3	Date:	080310	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM <i>3A</i>	<i>2A</i>

1

